

Date: Thursday, 9/14/2006 12:40:57 PM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : INITIAL PROTOTYPE TEMPLATE
Job Number : 00061A	
Estimate Number : 10068	
P.O. Number : <i>N/A</i>	Part Number : INITIAL PROTOTYPE <i>D3046-041</i>
This Issue : 9/14/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3046
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : 8/1/2006 Type : LARGE FAB ASSY	Drawing Revision : <i>N/A</i>
Previous Run : 00060A	Material : <i>N/A</i>
Written By : _____	Due Date : 6/8/2006 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Project #: _____	
Description: _____ D3046 OH-58 LUG	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MFG ENGINEERING MFG ENGINEERING



Comment: Setup: 0.00Hrs/Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

- Batch : *M100841* (*M174R0750*)
- Mut. batch : *M101463* (*M3045116A*)
- Make parts as per Dwg D3046 *SIB 06/09/21* ②
- QCS
- Weld ass'y as per Dwg D3046 & Q51004
- QC9 *welding rod 17-4 batch: M18774* ②
- Issue P/O : *2122* *06.09.22* ②
- Hardening *06/09/25* ②

2.0 M4130NS100

4130 Sheet .100



Comment: Qty.: 1.5000 sf(s)/Unit Total : 1.5000 sf(s)
 4130 Sheet .100

Receive + Inspect
 for Damage etc

Rynn Dussan 06/10/05 ②

PRELIMINARY ISSUE

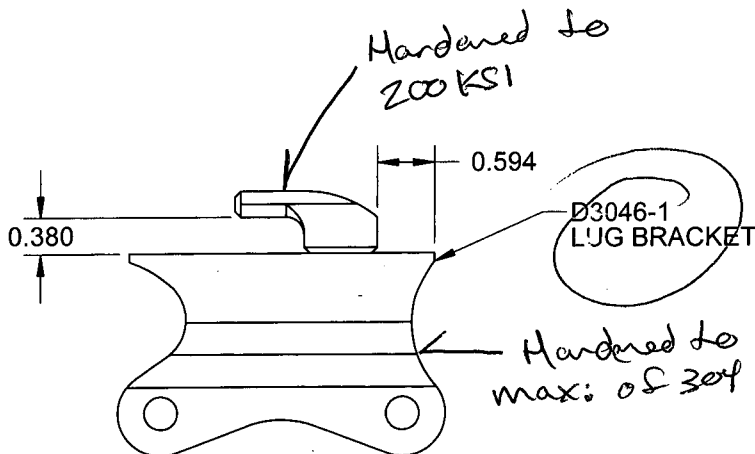
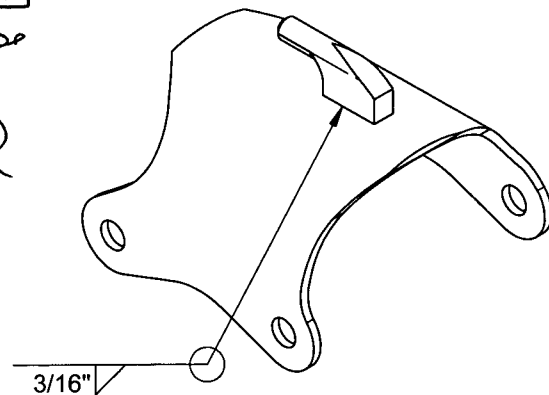
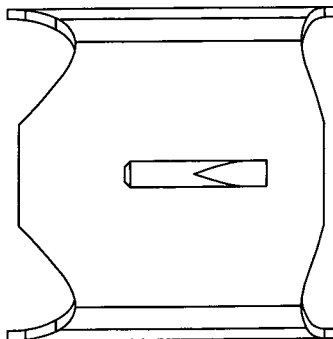
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3046	REV. B SHEET 1 OF 3
DATE 06.06.01		TITLE LUG BRACKET	SCALE 1:2
A	01.08.23	NEW ISSUE	
B	06.06.01	REMOVED D3046-3, ADDED D3046-5	

UNDER REVIEW

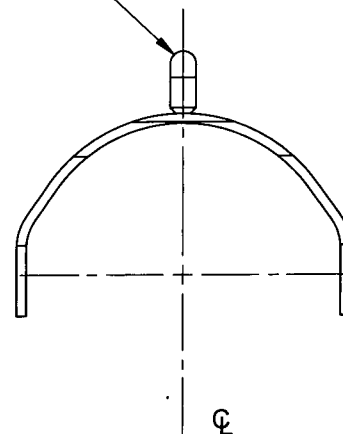
06.09.11 CB

prototype

qty: 2



D3046-5
HOOK



QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

D3046-041 GROUND HANDLING LUG ASSEMBLY

NOTES:

- 1) FINISH: ~~POWDER COAT ASSEMBLY WHITE GLOSS (REF 4.3.5.2) PER DART QSI 005 4.8.~~
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMETRICAL ABOUT ϕ

1866 565-668L

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PRELIMINARY ISSUE

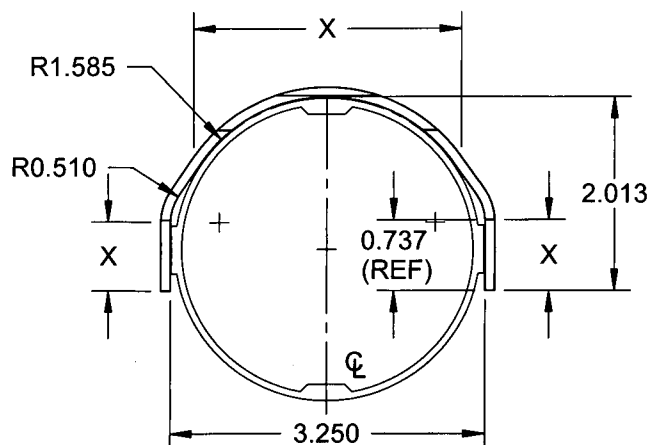
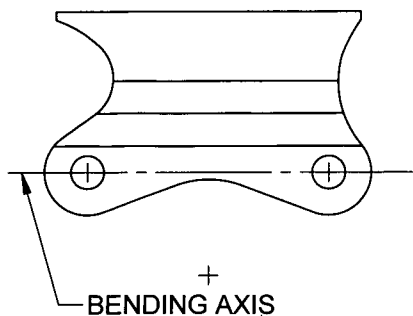
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CHECKED	APPROVED	DRAWING NO. D3046	REV. B SHEET 2 OF 3
DATE 06.06.01		TITLE LUG BRACKET	SCALE 1:2

UNDER REVIEW

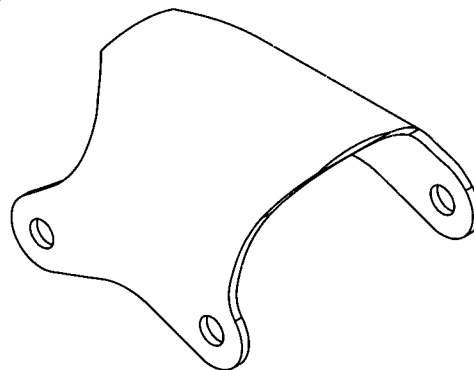
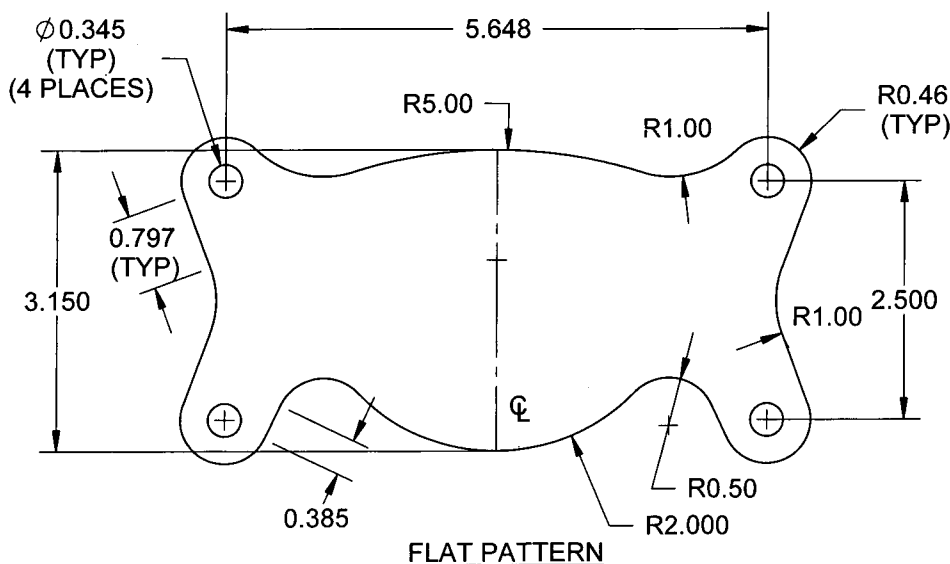
06.09.11 *CB*

prototype

qty: 2



D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.020" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.



D3046-1 LUG BRACKET

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET 0.109" THICK (12 GAUGE) (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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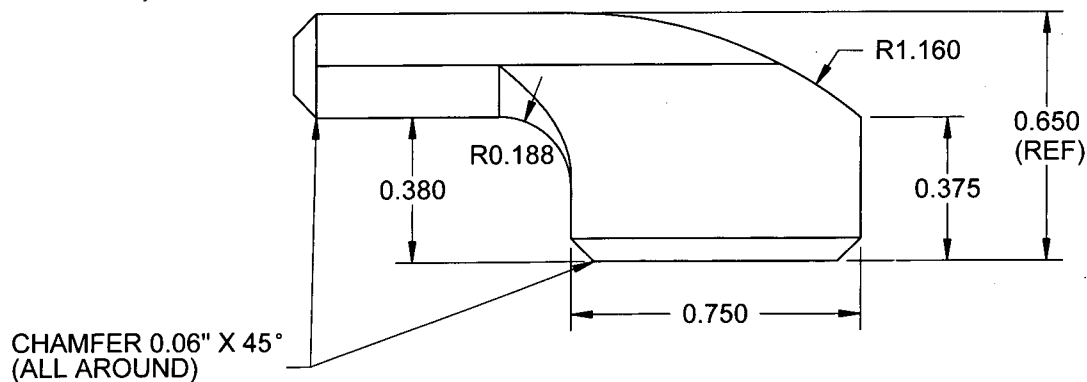
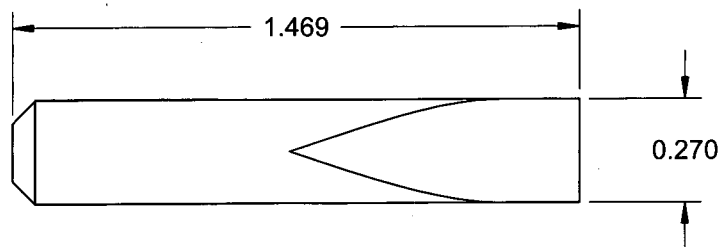
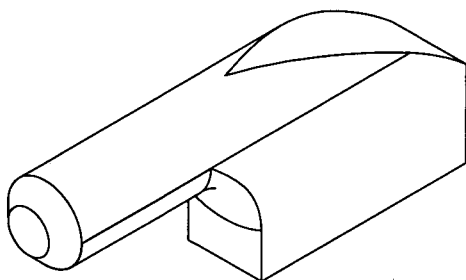
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PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.06.01		TITLE LUG BRACKET	SCALE 2:1

UNDER REVIEW
06.09.11 CB
prototype

g+y:2



D3046-5 HOOK

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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AC AERO

INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 79711-1

AS ROAD, OAKVILLE, ONTARIO
L6L 2X5
(905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VERITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

10/02/2006

MM / DD / YYYY

PAGE: 1

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
10/02/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
274716		COD

ART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
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-041

EA 2 2

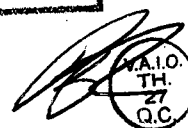
Process Specifications:

SOLUTION ANNEALED THEN HEAT TREATED TO
H900 COND. PER AMS 2759-3D
100% HARDNESS CHECKED AS PER ASTM E-18
MATERIAL: 304/17-4 SS

B00061A

100% HARDNESS TESTED

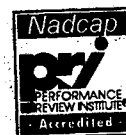
2 pcs → 42/43 HRC



we hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant
also in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



HEAT